



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G14331-3G

Job Sheet 172382



2/1/16

Part No: RBW6305G14331-3G

Job Qty: 3 ea

Part Name: Upper Module Lip Seal Installer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G14331-3G Rev 1 IPP Rev A 18.02.15 IPP Rev A New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		4/16/18	0.00	0.00	Purchasing		AT 18/05/01
110	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging2		AT 18/05/01
120	QC	3 pcs		4/16/18	0.00	0.00	QC6		38
130	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging3	DAS	MAY 02 2018
140	QC21-FG	3 Ea		4/16/18	0.00	0.00	QC21	21 MAY 02 2018	GA 163

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 037054 MANUFACTURE RBW6305G14331-3G AS PER
Descriptions: DWG -Certificate of conformity is required

FEB 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G14331-3GP	Upper Module Lip Seal Installer	3 (1 ea)	100-Purchasing	50674/18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G14331-3GP	3	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation

Job No: 172382
Mfg Date: 05/01/18

Packaging

Change No:

Operation:

Revision:

Serial No/Batch: S067419

PART NO: RBW6305G14331 - 3G

Upper Module Lip Seal Installer



S067419



Container No:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Root Cause

Environment ☐	No Re-verificati ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Setup ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Testing ☐
Internal Transport ☐	Poor Informatior ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Improvement ☐
Substation ☐	Process Improvement ☐
Past Expiry Date ☐	Manufacturing Process ☐
Misidentified ☐	Past Due ☐

Cleaning

Heat Treat

Wave/Twist in Tube

Marks/Chatter

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

Out of Sequence

Off-set

Mislabeled

Fit/Function

Misaligned/off center

ge

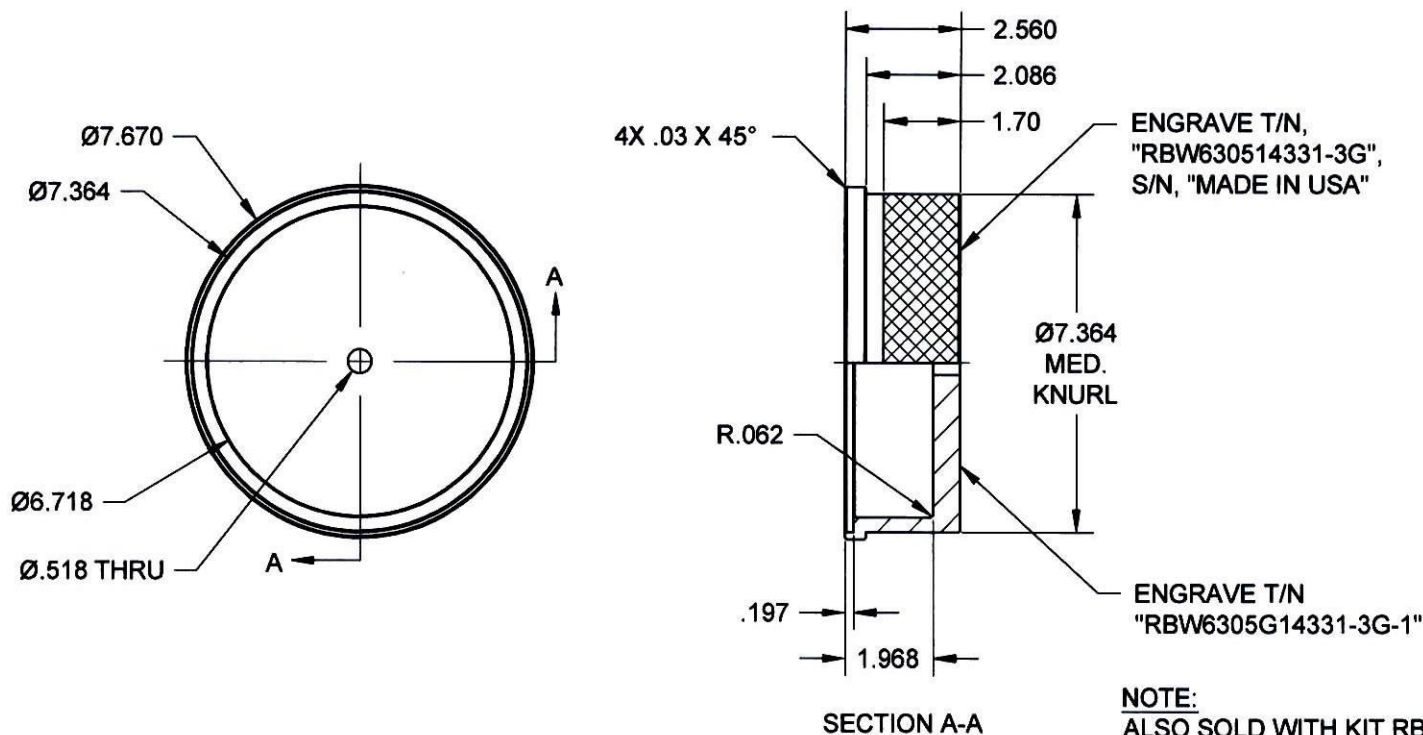
lled

☐	Positioned Wrong
☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Drawing
☐	Finish
☐	Misread
☐	Turning Sequence

OTHER :

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D -1 ENGRAVE NOTES, CH'D TITLE FROM DRIVE QUILL SEAL GUIDE PER R.W. CH'D -3 ENGRAVE NOTE PER R.W.	5/6/11	RJC	RW
B	CH'D TOOL NAME WAS UPPER MODULE LIP SEAL INSTALLER IS TOOL, UPPER MODULE LIP SEAL INSTALLER TO MATCH PARTS MANUAL.	11/1/13	RJC	RW
1	-1 CH'D DIM WAS 1.800 IS 1.70. -3 CH'D DIM WAS Ø8.250 IS (Ø8.250). CH'D TOLERANCE ON NON-CRITICAL PARTS.	5/13/14	DPD	GE



NOTE:
ALSO SOLD WITH KIT RBW6305G01531-3G,
BOX ONE RBW6305G19631-3G.

RED BARN MACHINE	
TITLE TOOL, UPPER MODULE LIP SEAL INSTALLER	
DWG NO. RBW6305G14331-3G	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	METRIC REF.
XXX ± .005	.XXmm ± .1mm
XX ± .01	FRACTIONS ± 1/32
X ± .1	ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CLOUGH	
APPROVED: <i>D. Wood</i>	
HEAT TREAT	
FINISH CLEAR ANODIZE	
SPEC MIL-A-8625F, TYPE II, CLASS I	
USED ON MODEL	
AW139	
SCALE 1:4	DATE 2-4-11
SHEET 1 of 2	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg
			-1	1	TOP	6061	Ø7-3/4 x 2-13/16	1
			-3	1	BASE	6061	Ø8-1/4 x 2-7/8	2
ASSY #								

-1
TOP

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



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PURCHASE ORDER PO039084

Items										
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD) Extended Price
Line Item Note job# 172405										
23	RBW6305G13731-3GP			Gimball Carbon Seal Remover As Per Dwg RBW6305G13731-3G Rev. 2	Firmed	4/16/18	3 Ea ✓ 3x	0 Ea	3 Ea	\$362.28/Ea \$1,086.84 AT 1804/26
Line Item Note job# 172401										
24	RBW6305G13231-3GP			Gimball Carbon Seal Installer As Per Dwg RBW6305G13231-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$984.42/Ea \$2,953.26
Line Item Note job# 172399										
25	RBW6305G14031-3GP			Gimball Carbon Seal Remover As Per Dwg RBW6305G14031-3G Rev. 2	Firmed	4/16/18	3 Ea ✓ 3x	0 Ea	3 Ea	\$639.24/Ea \$1,917.72 AT 1804/01
Line Item Note job# 172397										
26	RBW6305G14331-3GP			Upper Module Lip Seal Installer As Per Dwg RBW6305G14331-3G Rev. 1	Firmed	4/16/18	3 Ea ✓ 3x	0 Ea	3 Ea	\$758.42/Ea \$2,275.26 AT 1805/01
Line Item Note job# 172382										
27	RBW6305G18251-3GP			Guide Pumps/Ecs Drive Quill Seal Housing Installer As Per Dwg RBW6305G18251-3G Rev. A	Firmed	4/16/18	3 Ea ✓ 3x	0 Ea	3 Ea	\$132.32/Ea \$396.96 AT 1804/16
Line Item Note job# 172381										
28	RBW6305G17631-3GP			Tool Pump 1-2-3 Drive Quill Lip Seal Remover As Per Dwg RBW6305G17631-3G Rev. B	Firmed	4/16/18	3 Ea ✓ 3x	0 Ea	3 Ea	\$496.30/Ea \$1,488.90 AT 1804/26
Line Item Note job# 172378										
29	RBW6305G17931-3GP			Tool Pump 1-2-3 Drive Quill Lip Seal Installer As Per Dwg RBW6305G17931-3G Rev. B	Firmed	4/9/18	3 Ea ✓ 3x	0 Ea	3 Ea	\$392.72/Ea \$1,178.16 AT 1804/16
Line Item Note job# 172377										
30	RBW6305G17131-3GP			Drive Quill Seal Housing Removal Tool As Per Dwg RBW6305G17131-3G Rev. 3	Firmed	4/16/18	3 Ea ✓ 3x	0 Ea	3 Ea	\$905.64/Ea \$2,716.92 AT 1804/26
Line Item Note job# 172376										

DAE
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9-89



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 039084 Dated: 04/27/2018

Our Order / Job No: 06AWT Order Qty: 3

Part Name: Tool, Upper Module Lip Seal Installer

Part Number: RBW6305G14331-3G

Lot Size: N/A Ship Date: 04/27/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6305G14331-3G Rev: 1

Material Size and Type: -1/6061 ALUM; -3/6061 ALUM.

Material Specifications: ALUM.- ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments. DAS
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2-88
MAY 02 2018

Date: 04/27/18

Signed: 

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